

Date: Wednesday, 22/04/2009 10:59:35 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	EXTENSION TUBE ADJUSTMENT
Job Number :	47365		
Estimate Number :	12073		
P.O. Number :		Part Number :	PB6743001293 GN
This Issue :	22/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 PAGE38
First Issue :	11	Project Number :	N/A
Previous Run :	44971	Drawing Revision :	B1
	Type :	Material :	
	MACHINED PARTS	Due Date :	23/04/2009
Written By :		Qty:	10
Checked & Approved By :	MF 09-04-22	Um:	Each
Comment :	Est. A 05.08.29 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M7075T6R2000	7075 RD bar 2.00
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Comment: Qty.: 0.1575 f(s)/Unit Total : 0.6300 f(s)
 Material: 7075-T6511 Bar Ø2.00 (QQ-A-200/11)
 (M7075T6R2.000)
 Folio Rev: B1
 Dwg Rev: B1
 Identify for B67-43001-293
 Batch: M108595

09.05.03

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Turn as per Folio FA 552 & Dwg B67-43001
 Test fit on knurling Jig DT9423

09.05.03

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09.05.03

4.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL MILLING MACHINE
 Knurl as per Dwg B67-43001 using 1.200" pitch knurling wheels
 Using DT 9423

09.05.03

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09.05.03 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 09/05/03 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL

09-05-06

(110)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask threaded section and inside bore

START TIME:

2:30

OVEN TEMPERATURE:

320°

FINISH TIME:

3:00

FL 09/05/06

(18)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-09-07

(210)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

439A

9/5/7 - 1 carl.

(10x)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/07

Job Completion



mf 09-05-07

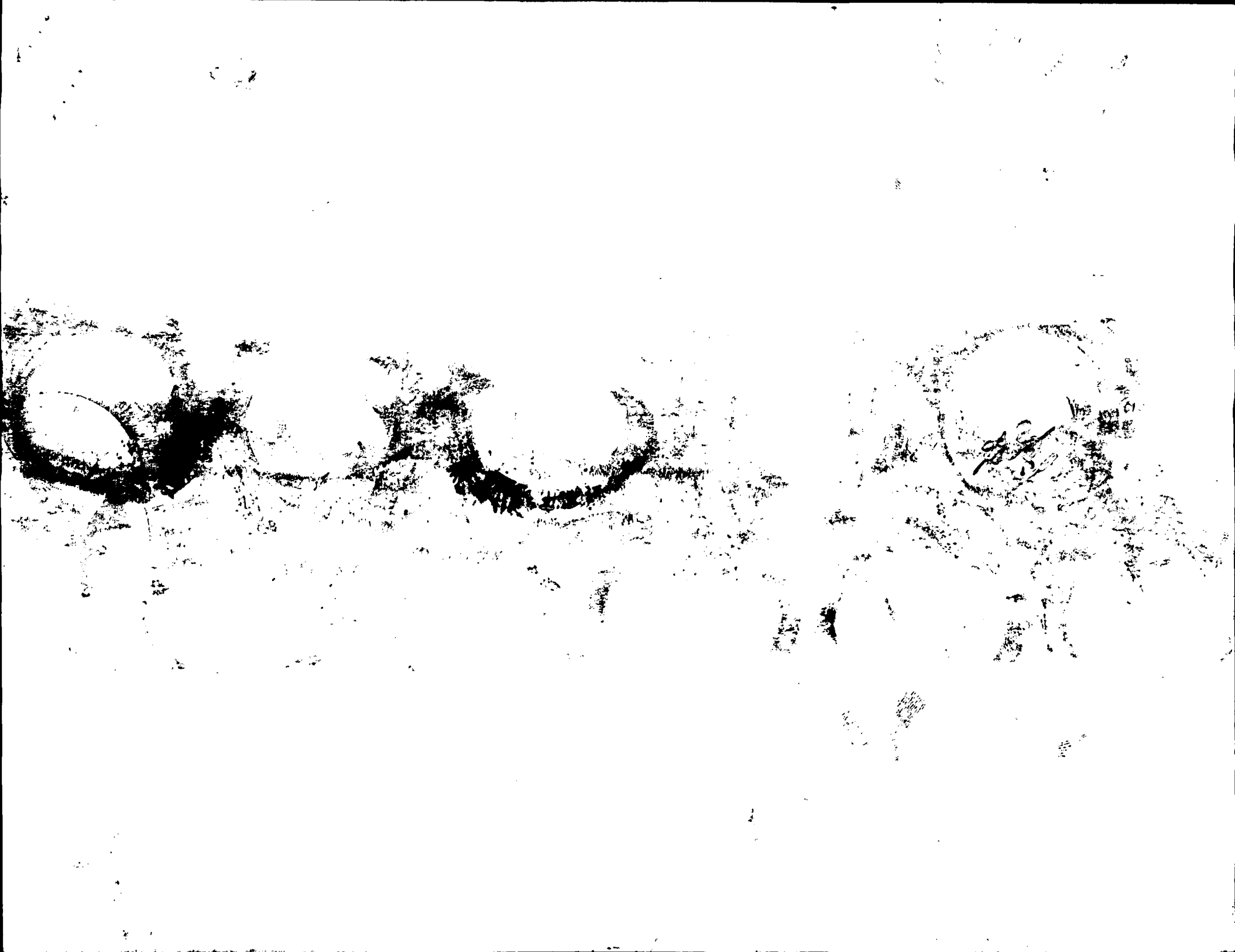
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

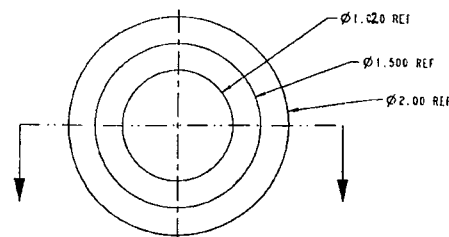
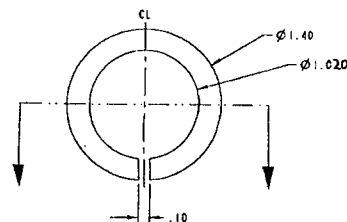
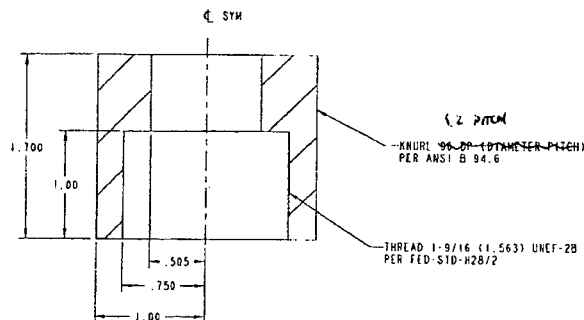
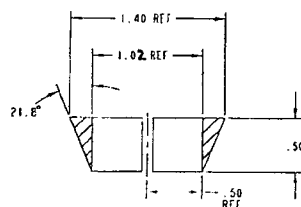
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
46-11-20



① -291 CLAMP BUSHING
JLK
MATL: 6061-T6, 00-A-200/8
SCALE 2.000

① -293 EXTENSION TUBE ADJUSTMENT FITTING
XLM
MATL: 7075-T6511, 00-A-200/11
SCALE 2.000

#46-11-20

PREMIER AVIATION, INC.
3601 Aviation Parkway, Grand Prairie, Texas 75050
DATE: 08/01/81 BY: JLM
D10SUV8 B67-43001
SCALE: 1"=1" SHEET: 38 OF 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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